

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004091**Date Inspected:** 18-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Bay 3

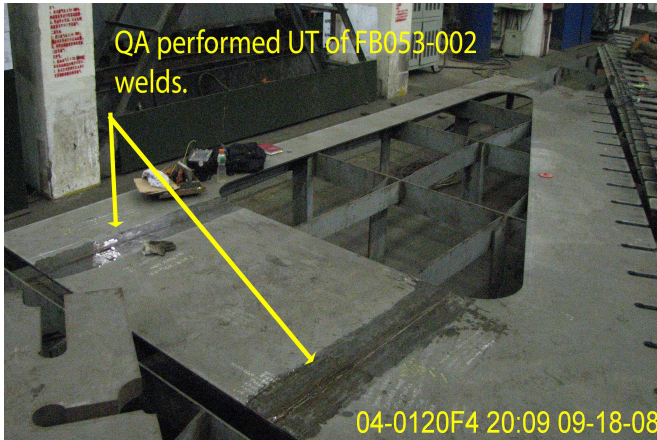
The QA Inspector performed MT verification of Critical Weld Repairs (CWRs) on the skewed stiffener plates for the side plates. There were 5 CWR's that ZPMC had informed Caltrans QA they would be performing the MT inspection on. The CWR's are as follows; B-CWR158 had 18 locations, B-CWR148 had 10 locations, B-CWR 154 had 11 locations, B-CWR 156 had 7 locations and B-CWR157 had 1 location. The MT that was examined by the Caltrans QA Inspector was for final MT of cover pass at the specified locations as listed within the approved CWR's. Items observed appear to comply with project specifications. ZPMC Inspection personnel had previously accepted magnetic particle inspections these welds. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

Bay 8

The QA Inspector performed random AWS D1.5 ultrasonic inspections of OBG floor beam welds FB053-002-001, FB053-002-014 and FB053-002-015. ZPMC Inspection personnel had previously ultrasonically inspected and accepted these welds. Items observed appear to comply with project specifications. ZPMC Inspection personnel had previously ultrasonically inspected and accepted these welds. Items observed appear to comply with project specifications. See the TL6027 ultrasonic test report for additional information.

WELDING INSPECTION REPORT

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Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
